

Work Order ID 148968

Tuesday, July 12, 2016 1:23:52 PM

148968

Page 1

Item ID: D5355-04T-1

Accept

N900040100Setup Start ***NS1***

Revision ID: SUPPORT

Item Name: Aft Clamp Assembly

Stop ***NS2***

Start Date: 7/12/2016 Start Qty: 2.00

2

Required Date: 7/19/2016 Req'd Qty: 2.00

2

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan:

DAS

Date: JUL 12 2016

Tooling:

Date:

Run Start ***NR1***

QC:

21

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5355

B A OFB 16/07/12

100

0.01

100

BAND SAW

Bandsaw

Memo

0.03

Jeaspa Bandsaw

Cut Blanks at 6.200"

J.A 16/07/12

2

φ

DAS
08
9-89

110

0.01

110

HAAS CNC VERTICAL MACHINING #1

HAAS 5AXIS

Memo

0.11

HAAS CNC vertical machine #5

1-Machine per folio FB434

DWG REV: B

FOLIO REV: AA

J.A 16/07/12

2

φ

DAS
08
9-89

2- deburr and break all sharp edge as per dwg

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 148968

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148968

Page 2

Item ID: D5355-041
 Revision ID:
 Item Name: Aft Clamp Assembly
 Start Date: 7/12/2016 Start Qty: 2.00
 Required Date: 7/19/2016 Req'd Qty: 2.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120
120
 QC
 Quality Control

DFB
 16/07/12

~~QC1- Inspection performed by CMM~~
QC2- Inspect parts off machine / FAI

~~Memo
 Inspect on CMM as per folio CMM028.
 DWG REV:
 CMM PROG. REV:~~

0.01

0.06

D.A 16/07/12

2

Ø

DA
 06
 9-8

130
130
 QC
 Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.01

② 16-07-13

DAS
 9
 9-89

140
140
 Outsource4
 Outsource process - Anodize

Outsource process-Anodize per QSI017 4.1.10.1

0.00

~~Memo
 Issue P/O to ATG~~

24.00

~~Black Anodize as per Dwg D5355~~

~~Certification of Conformity is required.~~

*Not required
 for testing.
 Pls. see Attach E-Mail
 DFB 16/07/12*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Work Order ID 148968

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Item ID: D5355-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Clamp Assembly

Start Date: 7/12/2016 Start Qty: 2.00

2

Required Date: 7/19/2016 Req'd Qty: 2.00

2

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Packaging

Memo

Certification of Conformity is required.

0.01

155

QC5- Inspect part completeness to step on W/O

0.00

155

QC

Quality Control

Memo

0.01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Work Order ID 148968

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148968

Page 4

Item ID: D5355-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Clamp Assembly

Start Date: 7/12/2016 Start Qty: 2.00 ***2***Required Date: 7/19/2016 Req'd Qty: 2.00 ***2***

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

160

160

Small Fab

Small Fab

Memo

0.06

-Assemble as per dwg.

-Secure nuts as per dwg. (Note #8)

-Apply procoat as per dwg.

Batch: _____

Exp. date: _____

VIA

DAS
9
9-89

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.01

Work Order ID 148968

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Page 5

Item ID: D5355-041

Accept

Revision ID:

N900040100Setup Start ***NS1***

Item Name: Aft Clamp Assembly

Stop ***NS2***

Start Date: 7/12/2016 Start Qty: 2.00

2

Required Date: 7/19/2016 Req'd Qty: 2.00

2

Cust Item ID:

Reference:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

Identify as per dwg & Stock Location: *Relin*

0.00

180

Packaging

Memo

0.00

Packaging

*② 1607.19*DAS
9
9-89

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.03

Quality Control

U 1607-20

Picklist Print

Tuesday, July 12, 2016 1:23:57 PM

Page 1

Work Order ID: 148968

Parent Item: D5355-041

Parent Item Name: Aft Clamp Assembly

148968

D5355-041

Start Date: 7/12/2016

Required Date: 7/19/2016

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 16.01.05 NEW ISSUE DD VERF:JLM
REV:B 16.01.26 REV.A DWG DD VERF:JLM
16/07/12 Per rev.B dwg. JFS Verified by: JLM

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No			100	f	15.3500	0.517	1.088421			

M6061T6B1 250X04 500

6061-T6 Bar 1.25 X 4.50

**

B.A 16/07/12

Location

MAT004

Loc Qty

Loc Code

→ m133038
m134776

15.35

3.35

12

1.0416 ft

~~D5316-1~~

~~Manufactured No~~

~~160~~

~~Each~~

~~0.0000~~

~~1 2~~

D5316-1

**

~~T-Bolt Strap~~

~~D5351-1~~

~~Manufactured No~~

~~160~~

~~Each~~

~~5.0000~~

~~2 4~~

D5351-1

**

~~T-Bolt Spacer~~

Location

prelim

Loc Qty

5

Loc Code

140611

5

Not required.
pls-see attach email
JFS
16/07/12

Picklist Print

Tuesday, July 12, 2016 1:23:57 PM

Page 2

Work Order ID: 148968

Parent Item: D5355-041

Parent Item Name: Aft Clamp Assembly

148968

D5355-041

Start Date: 7/12/2016

Required Date: 7/19/2016

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

160

Each

1,140.000

2

4

MS21043-3

Nut

**

Location

Loc Qty

Loc Code

EG

80

103691

80

FP001

11

m130673

11

GA

237

m133990

237

OVER007

400

m135058

400

ST302

306

m134861

306

ST304

106

m131340

106

NAS1149D0332J

Purchased

No

160

Each

1,794.000

2

4

NAS1149D0332J

Washer

**

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

562

m134848

562

GA

987

m135046

987

ST264

239

m134502

6

m134738

233

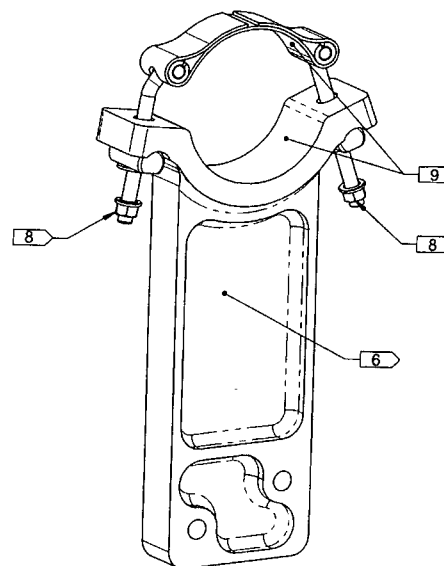
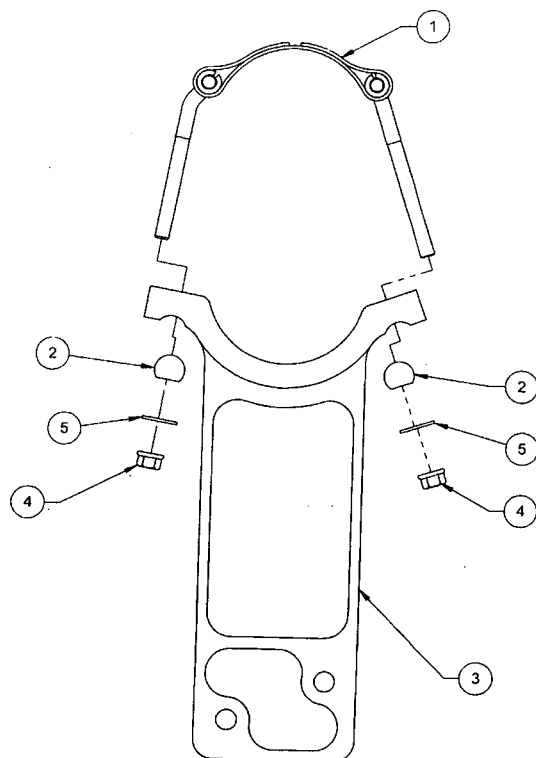
Not required.
pls. see attach e-Mail.

Tuesday, July 12, 2016 1:23:57 PM

AFS
16/07/12

Shop Packet Print

Page 2



ITEM	QTY -041	P/N	DESCRIPTION
	X	D5355-041	R66 AFT CLAMP ASSY
1	1	D5316-1	T-BOLT STRAP
2	2	D5351-1	T-BOLT SPACER
3	1	D5355-1	SUPPORT
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	NAS1149D0332J	WASHER
6	A/R	PROSEAL 890	SEALANT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148968 MWS
1607-12

D5355-041 R66 AFT CLAMP ASSY

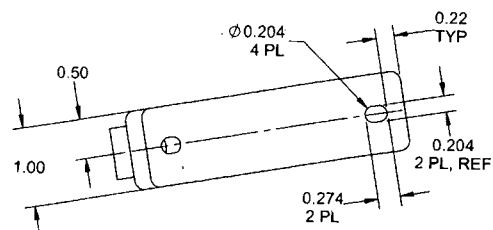
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.51 lbs
- 8) SECURE NUTS WITH 1-2 THREAD AS SHOWN
- 9) APPLY AN EVEN LAYER OF PROSEAL 890 (0.02" - 0.03" THICK) ON INSIDE SURFACE

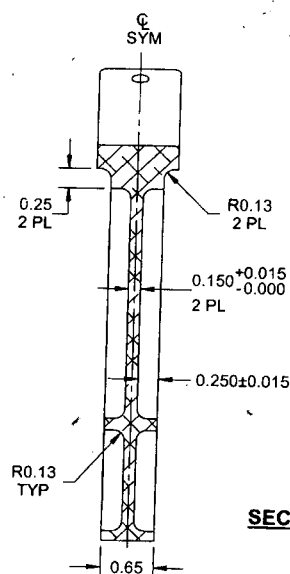
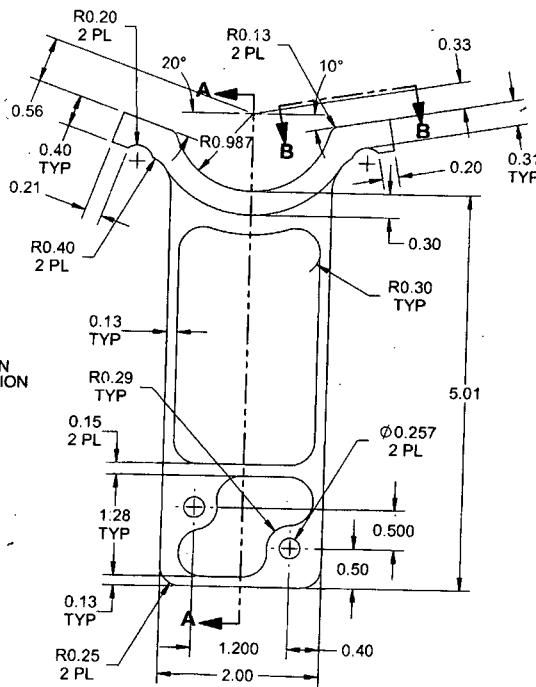
RELEASED
2016-06-29
EN 16-579

APPROVED

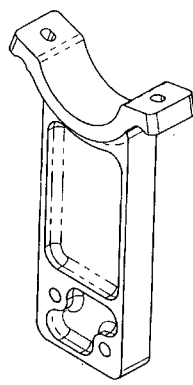
B	REDESIGN - 1/-041 (ZN B5-1, B5-2); ADD NOTE 9 (ZN A8-1); REMOVE -043	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5355	SHEET 1 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 AFT CLAMP ASSY	NTS
DATE	16.05.24	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION B-B



SECTION A-A



D5355-1 SUPPORT

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.43 lbs
- 8) UNDEFINED FEATURES CONTROLLED BY CAD FILE D5355-1 Rev. B.SLDPRT

RELEASED
2016-06-29

APPROVED

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JFS	D5355	SHEET 2 OF 2
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 AFT CLAMP ASSY	NTS
DATE	16.05.24	COPYRIGHT © 2015 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order:	148968
Description: SUPPORT		Part Number:	D5355-1
Inspection Dwg: D5355 Rev: B		Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/- .030	0.998	✓		Vern	GA-13
0.50	+/- .030	0.498	✓		"	"
Ø0.204	+ .005 / - .001	Ø0.204	✓		"	"
0.22	+/- .030	0.223	✓		"	"
0.204	+/- .010	0.204	✓		"	"
0.274	+/- .010	0.271	✓		"	"
0.33	+/- .030	0.329	✓		"	"
10°	+/- ½°	10°	✓		H-6	31006
R0.13	+/- .030	R0.125	✓		Angle M.	CNC-17
R0.987	+/- .010	R0.987	✓		R-6	ref.
20°	+/- ½°	20°	✓		"	"
R0.20	+/- .030	R0.200	✓		Angle M.	CNC-17
0.56	+/- .030	0.563	✓		R-6	ref.
0.40	+/- .030	0.400	✓		H-6	31006
0.21	+/- .030	0.219	✓		Vern	GA-13
R0.40	+/- .030	R0.406	✓		"	"
0.13	+/- .030	0.125	✓		R-6	ref.
R0.24	+/- .030	R0.246	✓		Mic	GA-03
0.15	+/- .030	0.150	✓		R-6	ref.
1.28	+/- .030	1.275	✓		Vern	GA-13
0.13	+/- .030	0.125	✓		H-6	31006
R0.25	+/- .030	R0.250	✓		Mic	GA-03
1.200	+/- .005	1.200	✓		R-6	ref.
2.00	+/- .030	2.000	✓		H-6	31006
0.40	+/- .030	0.401	✓		Vern	GA-13
0.50	+/- .030	0.500	✓		"	"
0.500	+/- .005	0.500	✓		"	"
Ø0.257	+ .006 / - .001	Ø0.258	✓		H-6	31006
5.01	+/- .030	5.014	✓		Vern	GA-13
R0.30	+/- .030	R0.297	✓		H-6	31006
0.30	+/- .030	0.300	✓		R-6	ref.
0.20	+/- .030	0.202	✓		Vern	GA-13
			✓		"	"

Measured by: D.A. DAS 08 9-89	Checked by: 9-89	QC Inspector:
Date: 16/07/12	Date: 16-07-13	Date:

Engineering Approval: (If necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Jean Francois Sauve

From: Jean-Luc Menard
Sent: July-08-16 2:34 PM
To: Jean Francois Sauve
Subject: FW: R66 Basket Parts Required

From: David Shepherd
Sent: Friday, July 01, 2016 4:19 PM
To: Jean-Luc Menard <jmenard@dartaero.com>; Denis Maranda <dmaranda@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>; Bill Beckett <bbeckett@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>; Roberto Fuentes <rfuentes@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: RE: R66 Basket Parts Required

JL,

Your questions are probably better answered by the Program Manager (Harvey), but my take is it would be acceptable to ship all parts together at the end of July/early August.

Since this project has been deemed "nice to have" by Sales & Mktg, a 4 week turnaround for these parts seems very reasonable to me.

Regards,
David

From: Jean-Luc Menard
Sent: June-29-16 7:28 AM
To: David Shepherd <dshepherd@dartaero.com>; Denis Maranda <dmaranda@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>
Cc: Harvey Siemens <hsiemens@dartaero.com>; Bill Beckett <bbeckett@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>; Roberto Fuentes <rfuentes@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: RE: R66 Basket Parts Required

Hi David,

We will start programing the parts Monday,beams will be cut next week.

As mentioned in last weeks e-mail(attached),we should have some results for the d5445 bent beams mid next week,at that point Roberto can decide if what we end up with is acceptable or not.

Due to vacation times and the flood of work this week,I would say 1st of August the partswill be in Calgary.

Some parts will be ready prior to that week,did you guys want everything at the same time or did you want us to ship whatever is ready as we manufacture them?

Let me know,

JL

From: David Shepherd
Sent: Monday, June 27, 2016 12:33 PM
To: Denis Maranda <dmaranda@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Jean-Luc Menard <jmenard@dartaero.com>

Cc: Harvey Siemens <hsiemens@dartaero.com>; Bill Beckett <bbeckett@dartaero.com>; Kim Johnston <kjohnston@dartaero.com>; Roberto Fuentes <rfuentes@dartaero.com>; Patrick Smith <psmith@dartaero.com>
Subject: R66 Basket Parts Required

All,

While Harvey was on holiday, I worked with Roberto to try to move the R66 basket project forward.

The following drawings have recently been approved in the Vault and are on their way to Hawkesbury with ECN 16-579 for processing :

- 1) D5350 Rev B (R66 Beam Assy)
- 2) D5354 Rev B (R66 Fwd Clamp Assy)
- 3) D5355 Rev B (R66 Aft Clamp Assy)
- 4) D5445 Rev A (Cross Beam Assy)

To re-do the structural test, Roberto would like the following parts in Calgary:

Qty	Part Number	Notes
1	D5445-041	Powder Coat not required, D5445-043 End Caps not required
1	D5445-042	Powder Coat not required, D5445-043 End Caps not required
1	D5350-1	Powder Coat not required, Drill 0.375 holes to 0.257, OK to cut on waterjet
1	D5350-3	Powder Coat not required, Drill 0.375 holes to 0.257, OK to cut on waterjet
1	D5354-1	Anodize not required
1	D5354-2	Anodize not required
2	D5355-1	Anodize not required

Please provide us with a date as to when we can have these parts in Calgary so that we can resume our testing. We will need to receive the parts with a signed Conformity Inspection Record. We will send the draft Conformity Inspection Record closer to the parts being ready for shipping.

David (Roberto's scribe)